

Date: Wednesday, 5/9/2007 8:16:13 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32247
 Estimate Number : 12788
 P.O. Number :
 This Issue : 5/9/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : SMALL /MED FAB
 Previous Run : 31398
 Written By : *JL 07-05-09.*
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-03-08 ec

Drawing Name : WEARSHOE
 Part Number : D356413
 Drawing Number : D3564 UNDER REVIEW
 Project Number : WP0002
 Drawing Revision : A
 Material :
 Due Date : 5/16/2007 Qty: 2 Um: Each

KEEP
IN ENG'G
LAB
RB
07.05.09

Additional Product

FOR ENGINEERING USE ONLY

Job Number: 

Seq. #:	Machine Or Operation:	Description:
1.0	M304S16GA	304/316 .063 Sheet 
		Comment: Qty.: 0.1785 sf(s)/Unit Total : 0.3570 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <i>M19052</i>
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET 1-Cut as per Dwg D3564 <i>Prog in Preliminary.</i> Dwg Rev: <i>U Review</i> <i>07/05/09</i> Prog Rev: <i>U Review/Rel</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE 
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT and DT

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32247

Part Number: D356413

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

RE 07.06.05

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

N/A NO RECOMMEND
RECOMMEND

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FOR ENGINEERING USE ONLY

Identify and Stock

Location: _____

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

RE 07/06/05

Job Completion



Job/Project Number: 00082

Design Engineer/Project Manager Signature: PJ Date: 07.05.03

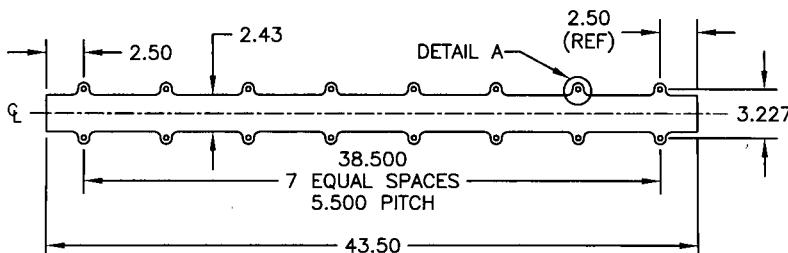
Design Manager Signature: N/A Date: _____

PROTOTYPE REQUEST FORM

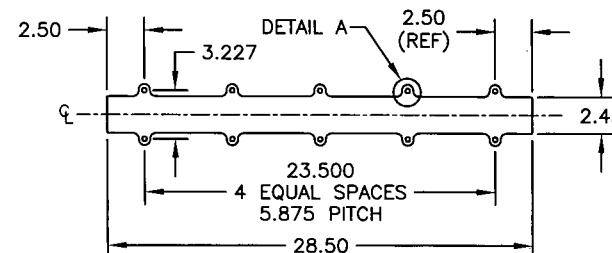
Item	Part Number	Drawing Number Date	Qty	Material Cert Required (Y/N)	Due Date	Complete Date	Comments
1	D3564-13	D3564 Rev C PRELIMINARY	1	N	07.05.09	<u>07.06.05</u>	PRELIMINARY ONLY, RETURN PARTS TO P. HUM

PROTOTYPE
PLEASE RETURN ALL IS-SUPPLIED
DATA TO ENGINEER

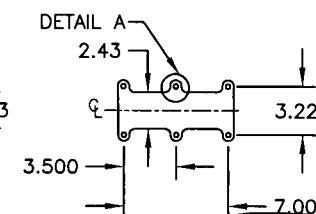
PA 07-05-03



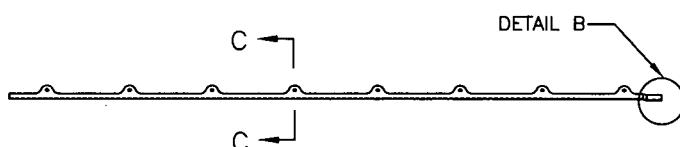
D3564-5F FLAT PATTERN



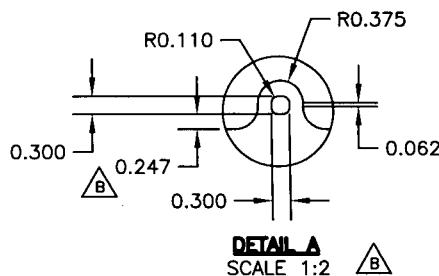
D3564-7F FLAT PATTERN



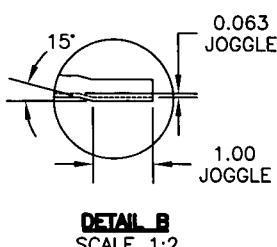
D3564-13F FLAT PATTERN



D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)

Material

ALSI 304/316, 16 GAUZE (0.063 THICK)
(REF M304S166A)

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DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3564	REV. C SHEET 2 OF 2
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:8	

DART AEROSPACE LTD

Work Order: 32247

Description: WEAR SHOE

Part Number: D356413

Inspection Dwg: D356413 Rev: UNDER Review

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.43	+/- 0.030	2.43	/		Vern	
B 3.500	+/- 0.010	3.499	/		Vern	
C 7.00	+/- 0.030	7.00	/		Vern	
D 3.227	+/- 0.010	3.222	/		Vern	
E 0.300	+/- 0.010	0.299	/		Vern	
F 0.300	+/- 0.010	0.302	/		Vern	
G 0.063	+/- 0.010	0.058	/		Vern	
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: RH	Prototype Approval: 	N/A
Date: 07/05/09	Date: 07.05.09	Date: 	N/A

Rev	Date	Change	SC 07.05.09	Revised by	Approved
		New Issue		KJ/RF	